

Date: Monday, 6/5/2006 7:47:48 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 27374		
Estimate Number	: 11474		
P.O. Number	: N/A	Part Number	: D3140303
This Issue	: 6/5/2006 S.O. No. : N/A	Drawing Number	: D3140.REV D1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D1
Previous Run	: 26798	Material	: N/A
Written By	: <i>SAID COMMENT BEHW</i>	Due Date	: 6/30/2006
Checked & Approved By	: <i>06-06-05</i>	Qty:	4 Um: Each
Comment	: Est. rev A 02.11.06 New issue KJ/RF		
	: Est. Rev B 06.04.18 New dwg rev. ecn781 EC		
	: EST rev.C 06.04.25 Waterjet EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 2.9166 sf(s)/Unit Total : 11.6663 sf(s)  
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063)  
 Batch: *m18556*

*m1 06 06 07 L*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 1-Cut as per Dwg:D  
 Dwg Rev: *D1*  
 Prog Rev: *D1*

2-Debur if necessary

*m1 06 06 07 (4)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*m1 06 06 07 (4)*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*06-06-06 (4)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

*G.A - Debur FF 06-06-13*

*H.M 06/06/14*

*(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-06-08	2	Delivering to be done before stocking. move to step. 5.0 Permanent change.					 06-06-08

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/15.

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/5/2006 7:47:48 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 27374

Part Number: D3140303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP 6/6/14 (4)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: */*

*AP 06/06/14 (4)*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP 06/06/15 (4)*

Job Completion



*U Double*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	<del>06.03.31</del>	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED  
05.12.01 *[Signature]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

**RELEASED**  
05.12.2015

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

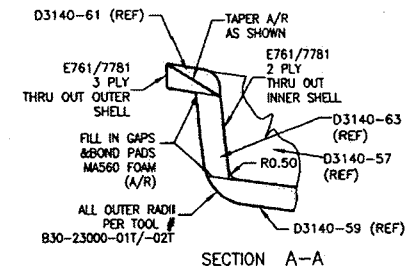
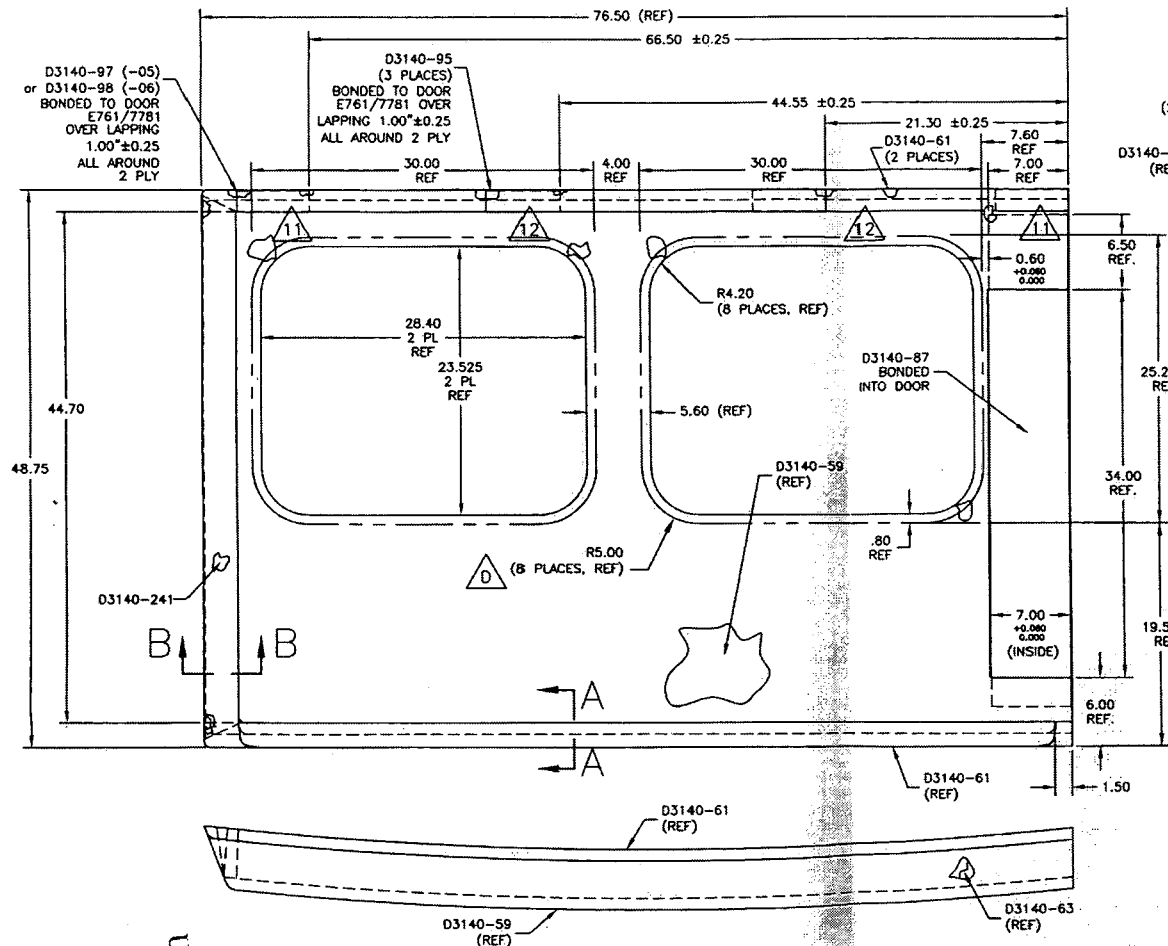
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

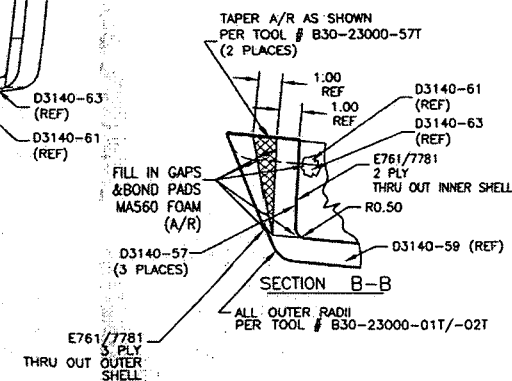
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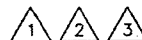
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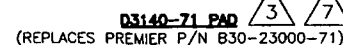
D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)  
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)  
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)



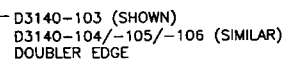
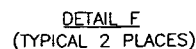
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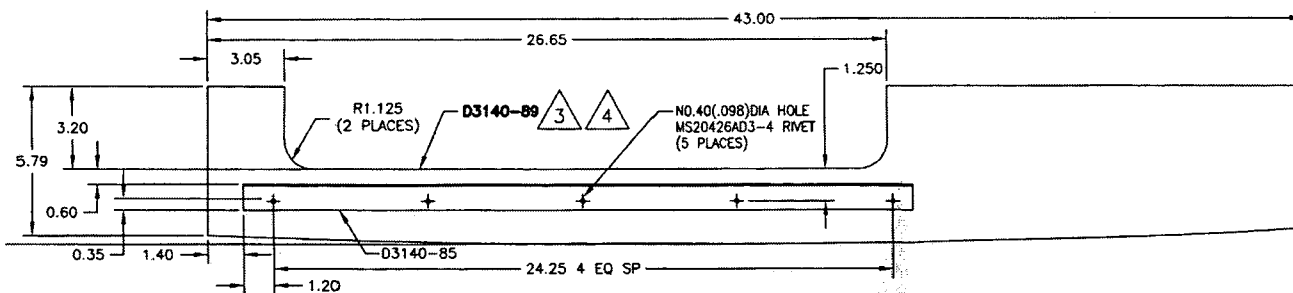
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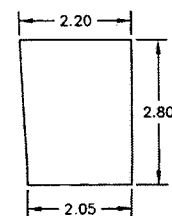
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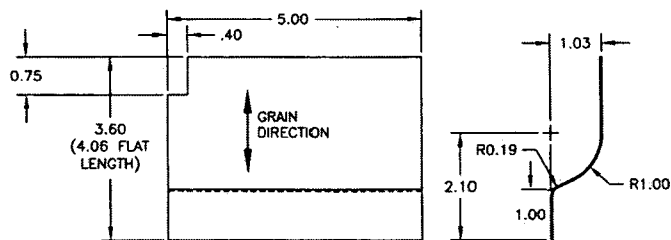




**D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)**  
**D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)**

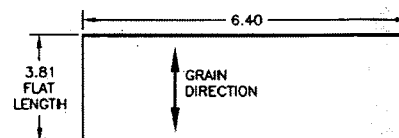


**D3140-101 DOUBLER** (REPLACES PREMIER P/N B30-23000-101)

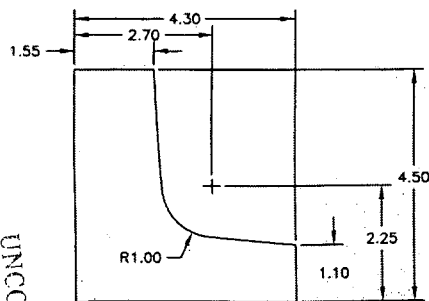
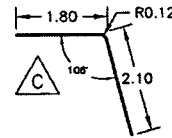


**D3140-91F FLAT PATTERN**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)

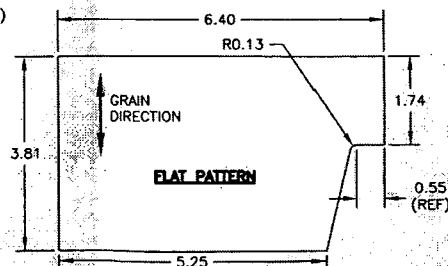
**D3140-91 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-91)  
**D3140-92 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



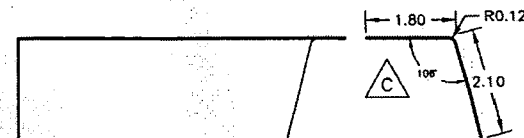
**D3140-95 DOUBLER** (REPLACES PREMIER P/N B30-23000-95)



**D3140-98 DOUBLER** (REPLACES PREMIER P/N B30-23000-99)



**D3140-97F FLAT PATTERN**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



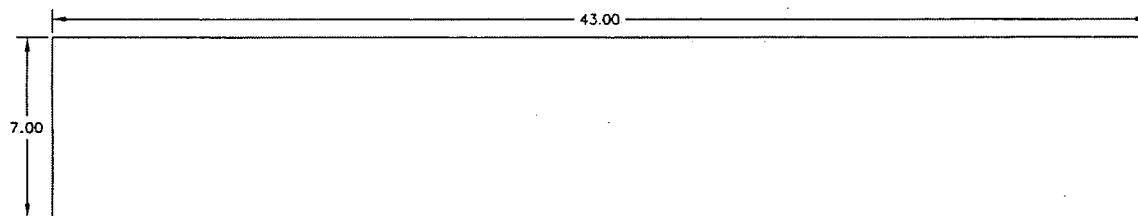
**D3140-97 DOUBLER** (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER** (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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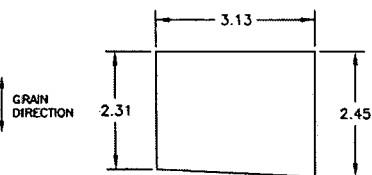
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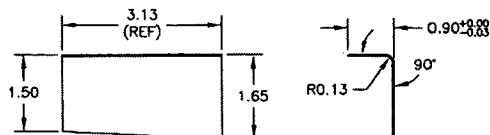
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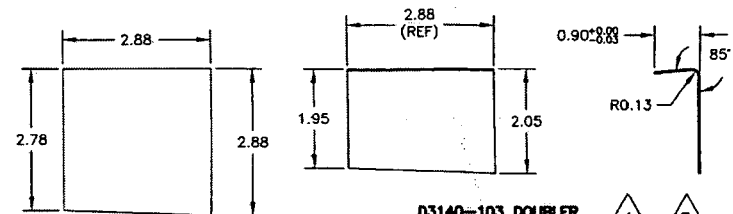
**D3140-87 DOUBLER**  $\triangle 4$   
(REPLACES PREMIER P/N 830-23000-87)



**D3140-105F FLAT PATTERN**  
(USED TO MAKE D3140-105/-106 BRACKETS)



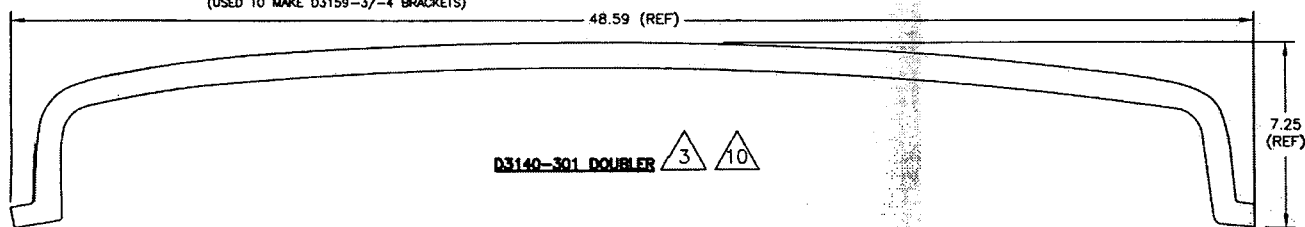
**D3140-105 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-106 OPPOSITE**



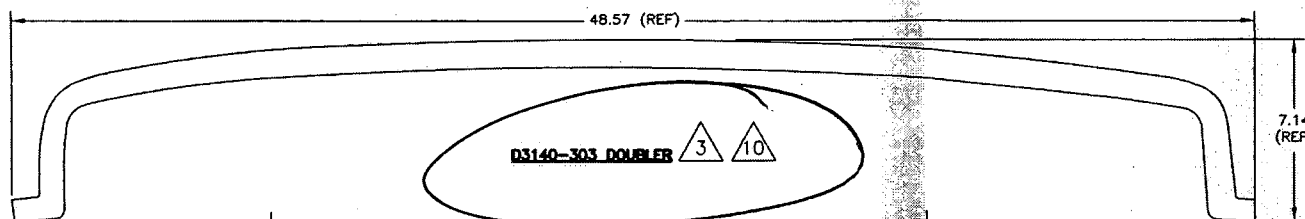
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)

**D3140-103 DOUBLER**  $\triangle 4$   $\triangle D$   
**D3140-104 OPPOSITE**

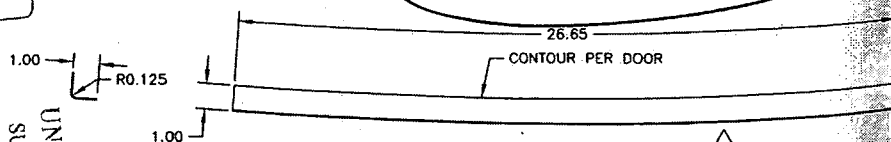
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-303 DOUBLER**  $\triangle 3$   $\triangle 10$



**D3140-85 ANGLE**  $\triangle 6$   
FLAT-PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N 830-23000-85)

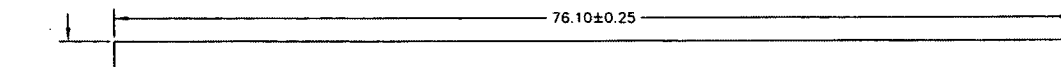
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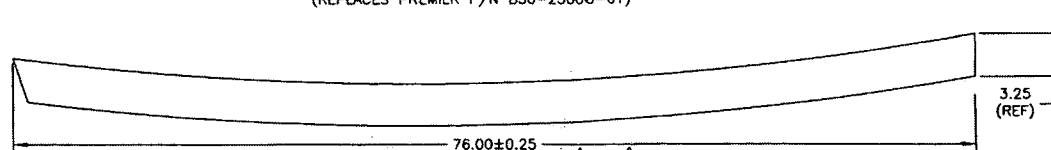
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DATE 05.11.23		TITLE DOOR	SCALE NTS

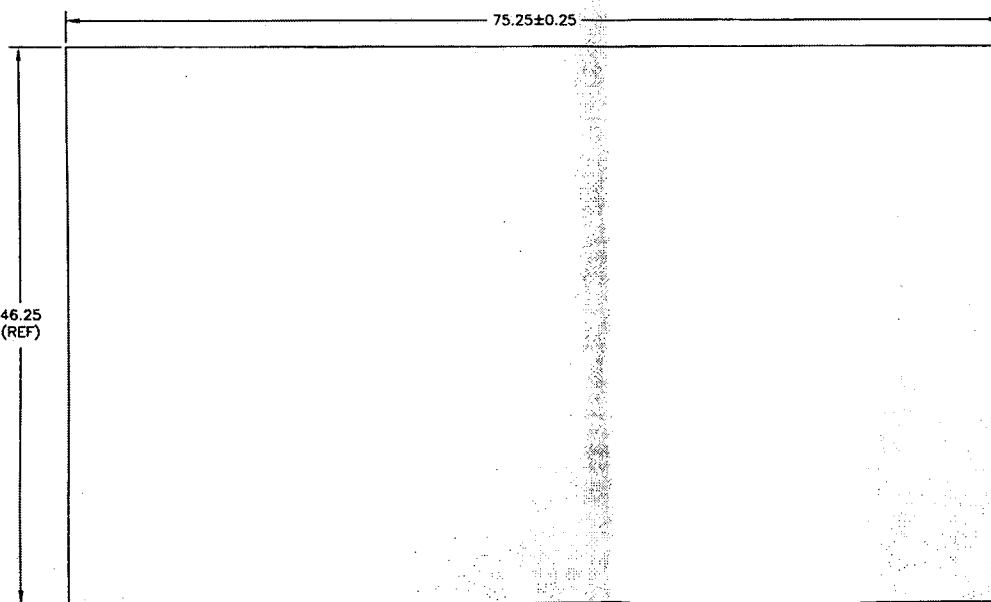
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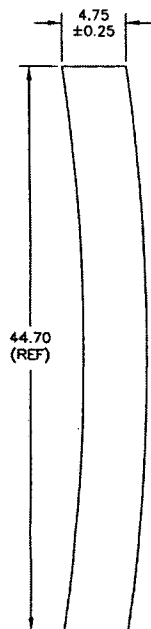
**D3140-61 PAD**  
(REPLACES PREMIER P/N B30-23000-61)



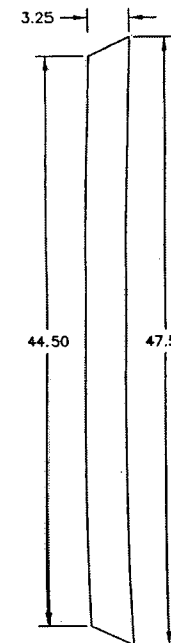
**D3140-63 PAD**  
(REPLACES PREMIER P/N B30-23000-63)



**D3140-59 PAD**  
(REPLACES PREMIER P/N B30-23000-59)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)



**D3140-241 DOOR**  
(REPLACES PREMIER P/N B30-23000-241)



**RELEASED**  
05.11.23

R1.00  
(2 PLACES, REF)

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DATE 05.11.23		TITLE DOOR	SHEET 7 OF 7
			SCALE NTS

